

**Work Order ID 68235**

Monday, April 11, 2011 7:44:13 AM



Page 1

Item ID: D3908-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Crosstube Lug Assembly, Aft

Start Date: 4/11/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 4/13/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D3908

C

100

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

4/11/12 (4)

110

0.00



Small Fab

Memo

0.00

Small Fab

1- Assemble as per dwg  
TRIM RIVETS 1.185" LONG

4/11/12 (4)

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

SB 11/6/13

(4)

**Work Order ID 68235**

Monday, April 11, 2011 7:44:13 AM



Page 2

Item ID: D3908-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Crosstube Lug Assembly, Aft

Start Date: 4/11/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 4/13/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Identify as per dwg & Stock Location: <u>S7D</u>	0.00							
Packaging	Memo	0.00							
Packaging									
140 	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

11/4/13

11/4/13

MF  
11-04-13

# Picklist Print

Monday, April 11, 2011 7:44:09 AM

Page 1

Work Order ID: 68235

Parent Item: D3908-041

Parent Item Name: Crosstube Lug Assembly, Aft


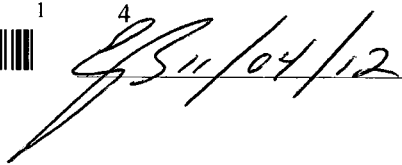

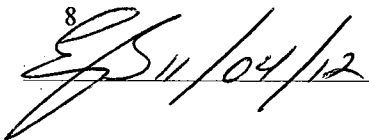

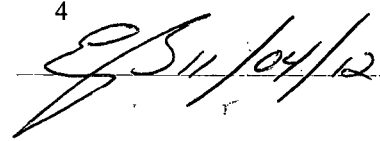
Start Date: 4/11/2011

Required Date: 4/13/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP RevA: New issue DD verified by:EC  
As per Rev B 10-04-06 VERIFIED BY:DD  
10.05.27 DD verf:EC  
10.05.28 DD verf:EC  
IPP REV B:  
IPP Rev:C as per PC1  
IPP Rev:D per ECN10-581

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2690-6  Lanyard Assembly		Manufactured	No			100	Each	37.0000	1	4			
													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST020				37					
				66509				17					
				66873				20					
D3908-1  Lug Plate, Aft Crosstube		Manufactured	No			100	Each	11.0000	2	8			
													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST090				10					
				66167				10					
				ST093				1					
				65624				1					
D3908-3  Stud Receiver, Lower		Manufactured	No			100	Each	9.0000	1	4			
													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST090				9					
				60228				1					
				66172				8					

# Picklist Print

Monday, April 11, 2011 7:44:10 AM

Page 2

Work Order ID: 68235

Parent Item: D3908-041

Parent Item Name: Crosstube Lug Assembly, Aft

Start Date: 4/11/2011

Required Date: 4/13/2011

Start Qty: 4.00

Required Qty: 4.00

D3908-5  
  
 Eyebolt Stud

Manufactured No

100 Each

19.0000

1

4



*EP 5/11/04/12*

Location

Loc Qty

Loc Code

GA

1

57428

1

ST090

18

59670

2

65625

8

66185

8

4

D3910-1  
  
 Crosstube Lug

Manufactured No

100 Each

7.0000

1

4



*EP 5/11/04/12*

Location

Loc Qty

Loc Code

st507

7

65631

7

4

D4091-1  
  
 Mounting Lug

Manufactured No

100 Each

12.0000

1

4



*EP 5/11/04/12*

Location

Loc Qty

Loc Code

ST460

12

65626

12

4

AN3C12A  
  
 Bolts

Purchased No

100 Each

85.0000

2

8



*EP 5/11/04/12*

Location

Loc Qty

Loc Code

ST351

85

116924

35

117313

50

8

Monday, April 11, 2011 7:44:10 AM

Shop Packet Print

Page 2

# Picklist Print

Monday, April 11, 2011 7:44:10 AM

Page 3

Work Order ID: 68235

Parent Item: D3908-041

Parent Item Name: Crosstube Lug Assembly, Aft

Start Date: 4/11/2011

Required Date: 4/13/2011

Start Qty: 4.00

Required Qty: 4.00

AN4C13A

Purchased

No

100

Each

72.0000

1

4



BOLT



*EP 5/11/04/12*

Location

Loc Qty

Loc Code

ST353

60

117366

60

ST357

12

114492

4

116914

8

*4*

MS17984-C413

Purchased

No

100

Each

25.0000

1

4



PIN, QUICK RELEASE



*EP 5/11/04/12*

Location

Loc Qty

Loc Code

ST315

25

116823

5

117343

20

*4*

MS20615-4M20

Purchased

No

100

Each

264.0000

6

24



RIVET



*EP 5/11/04/12*

Location

Loc Qty

Loc Code

GA

264

117071

264

*M115037*

Monday, April 11, 2011 7:44:10 AM

Shop Packet Print

Page 3

# Picklist Print

Monday, April 11, 2011 7:44:10 AM

Page 4

Work Order ID: 68235

Parent Item: D3908-041

Parent Item Name: Crosstube Lug Assembly, Aft

Start Date: 4/11/2011

Required Date: 4/13/2011

Start Qty: 4.00

Required Qty: 4.00

MS21043-3

Purchased

No

100

Each

1,056.000

2

8



Nut



*EB 11/04/12*

Location

Loc Qty

Loc Code

FG	80	
103691	80	
FP-B	-5	
112314	-5	
ST301	981	
112314	981	

MS21043-4

Purchased

No

100

Each

661.0000

1

4



Nut



*EB 11/04/12*

Location

Loc Qty

Loc Code

FG	40	
104603	40	
ST301	621	
114523	3	
116188	318	
116549	300	

NAS1149C0332R

Purchased

No

100

Each

5,061.000

4

16



Washer



*EB 11/04/12*

Location

Loc Qty

Loc Code

ST297	5061	
115832	22	
116304	55	
117291	4984	

*10*  
*6*

Monday, April 11, 2011 7:44:10 AM

Shop Packet Print

Page 4

# Picklist Print

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Parent Item: D3908-041



Parent Item Name: Crosstube Lug Assembly, Aft

Start Date: 4/11/2011

Required Date: 4/13/2011

Start Qty: 4.00

Required Qty: 4.00

NAS1149C0432R

Purchased

No

100

Each

6,590.000

2

8



Washer

*Ep 5/11/04/12*

Location

Loc Qty

Loc Code

ST297

6590

116900

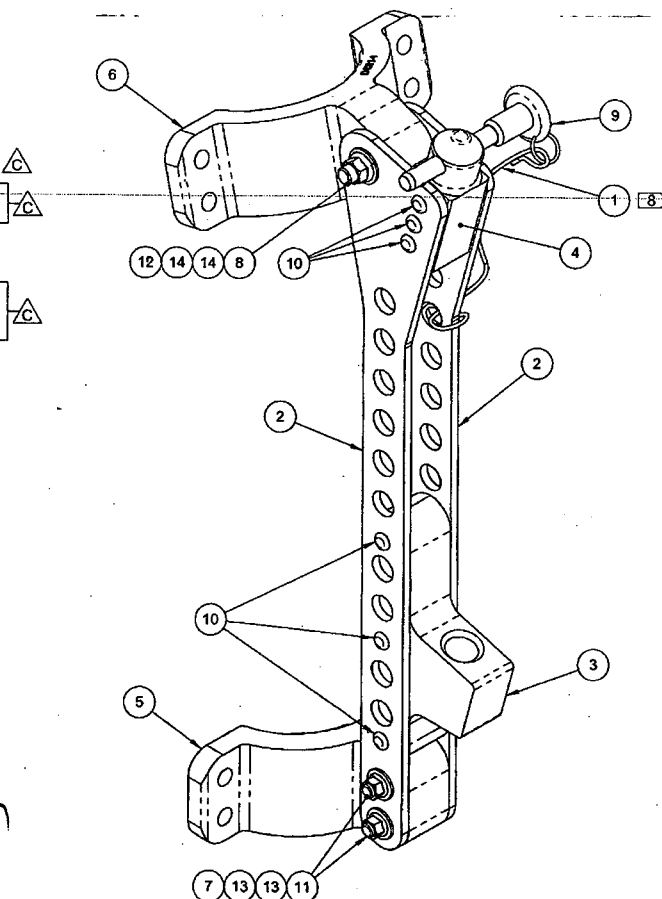
1590

117291

5000

8

ITEM	QTY.	P/N	DESCRIPTION
	X	D3908-041	X-TUBE LUG ASSY (AFT)
1	1	D2690-6	LANYARD
2	2	D3908-1	AFT X-TUBE LUG PLATE
3	1	D3908-3	STUD RECEIVER LOWER
4	1	D3908-5	EYEBOLT STUD
5	1	D3910-1	X-TUBE LUG
6	1	D4091-1	MOUNTING LUG
7	2	AN3C12A	BOLT
8	1	AN4C13A	BOLT
9	1	MS17984-C413	PIP PIN
10	6	MS20615-4M20	RIVET
11	2	MS21043-3	NUT
12	1	MS21043-4	NUT
13	4	NAS1149C0332R	WASHER
14	2	NAS1149C0432R	WASHER



**D3908-041 X-TUBE LUG ASSY (AFT)**

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3908-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 2.34 lbs
- 8) ATTACH TO D3908-1 BY LOOPING AROUND LIGHTENING HOLE FIRST AND THEN SECURE TO MS17984-C413 PIP PIN'S RING.

**RELEASED**  
2010-05-28  
W

C	REDESIGNED ITEM #2; ITEM#6 REPLACES QTY 1 ITEM#5; QTY 2 FOR ITEMS #7 & 11 WAS QTY 4, QTY 8 FOR ITEM #13 WAS 4, ADDED ITEMS #8, 12 & 14	MB	10.05.27
B	BOM: D3908-5 REPLACED WITH D3908-5. QTY 1 ADDED: D2690-6 & MS17984-C413. SHEET 5: ADDED D3908-5	JPH	10.04.06
A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH		
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.05.27		

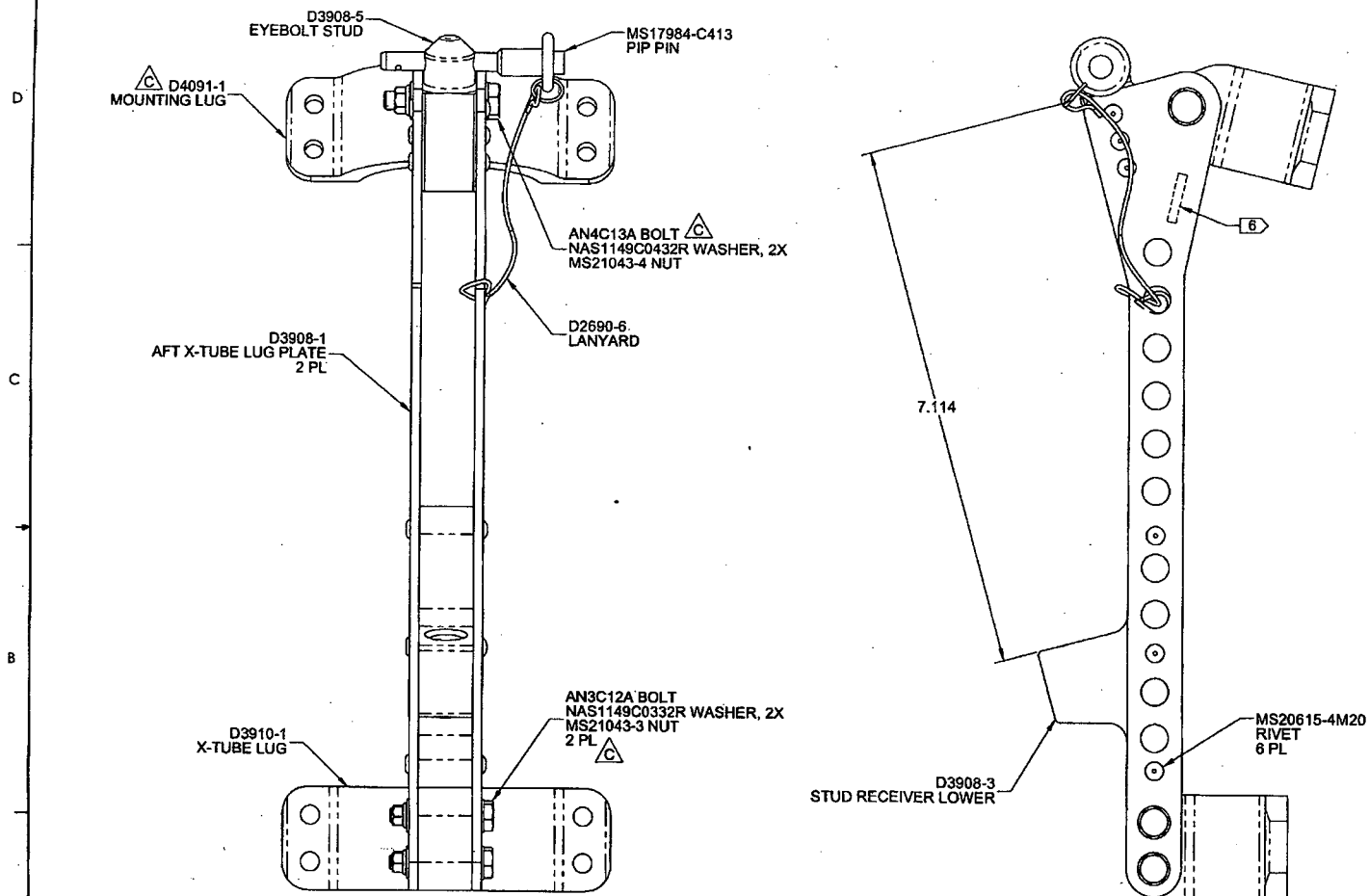
**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3908** REV. C  
SHEET 1 OF 5  
TITLE **X-TUBE LUG ASSY (AFT)** SCALE NTS

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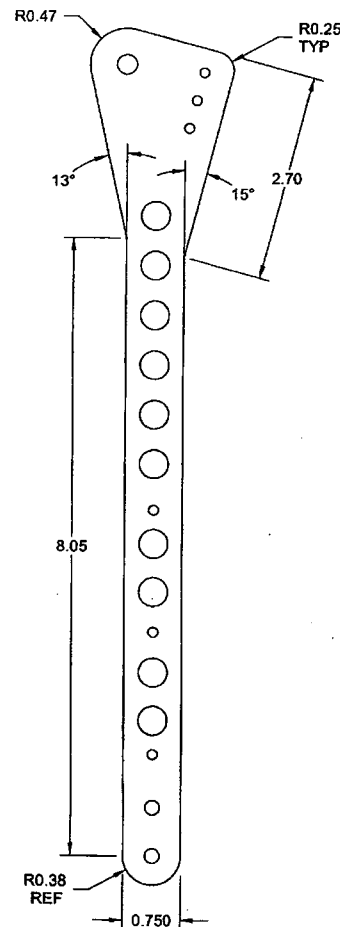
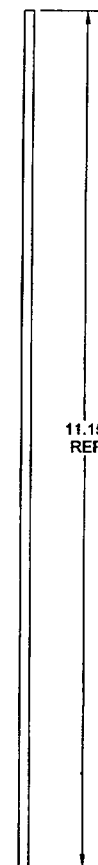
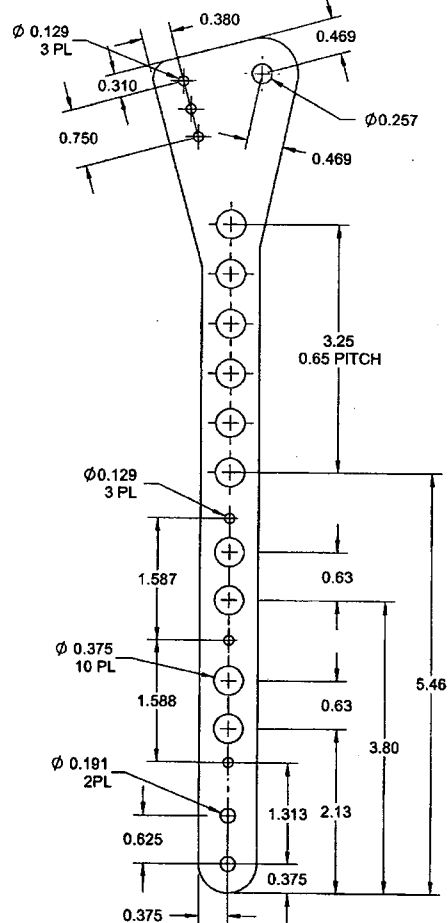


**D3908-041 X-TUBE LUG ASSY (AFT)**

**RELEASED**  
2010-05-28  
ND

DESIGN	JFH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO.	REV. C
CHECKED		D3908	SHEET 2 OF 5
MFG. APPR.		TITLE	SCALE
APPROVED		X-TUBE LUG ASSY (AFT)	NTS
DE APPR.		COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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8 7 6 5 4 3 2 1



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2010-05-28  
MPO

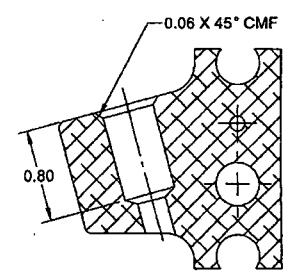
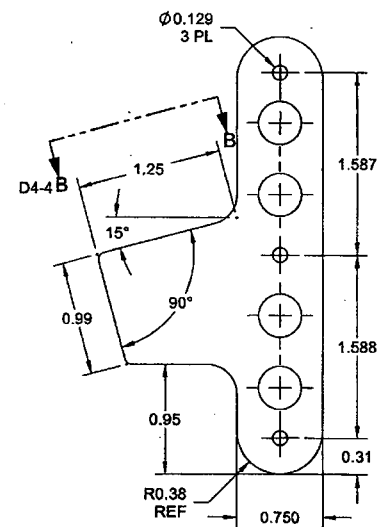
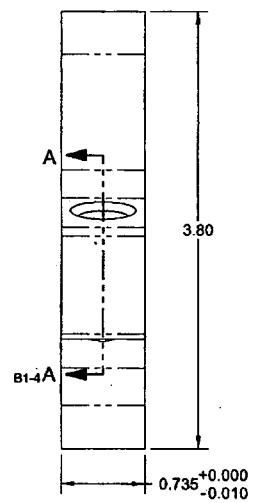
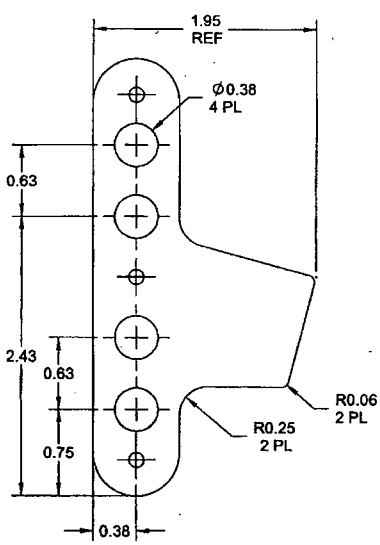
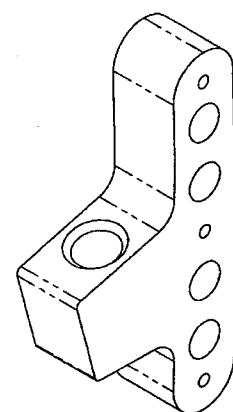
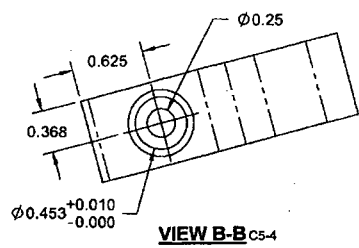
**NOTES:**

- 1) MATERIAL: 303/304/316 STAINLESS STEEL 0.125" SHEET ANNEALED 2B FINISH, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 PER DART SPEC M304S11GA OR M303S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.31 lbs

**D3908-1 AFT X-TUBE LUG PLATE**

DESIGN	JRH	<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3908	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		X-TUBE LUG ASSY (AFT)	NTS
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8 7 6 5 4 3 2 1



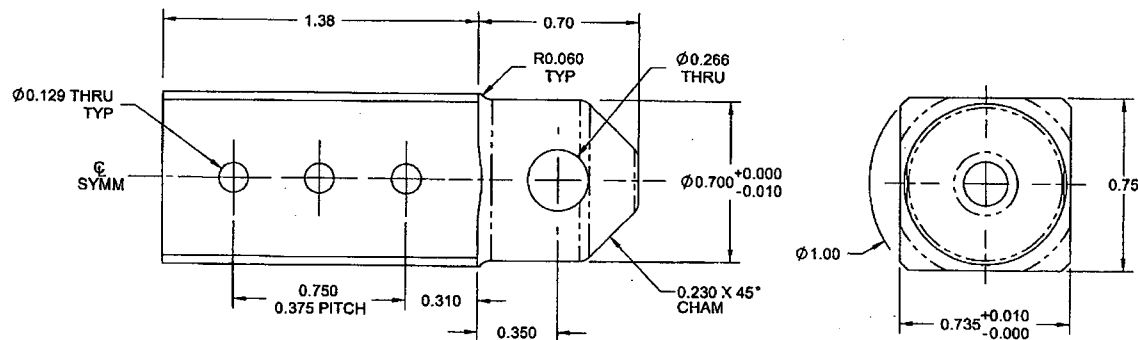
**D3908-3 STUD RECEIVER LOWER**

**RELEASED**  
2010-05-28

- NOTES:**
- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR, PER ASTM A276 PER DART SPEC M303B OR M304B
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: NONE
  - 7) WEIGHT: 0.69 lbs

*68235*

DESIGN	JFH	<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3908	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		X-TUBE LUG ASSY (AFT)	NTS
DATE	10.05.27	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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**D3908-5 EYEBOLT STUD**

**RELEASED**  
2010-05-28  
NMP

**NOTES:**

- 1) MATERIAL: 303/304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276 OR ASTM A582  
PER DART SPEC M303R OR M304R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.26 lbs

68235

DESIGN	JFH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO.	REV. C
CHECKED		D3908	SHEET 5 OF 5
MFG. APPR.		TITLE	SCALE
APPROVED		X-TUBE LUG ASSY (AFT)	NTS
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DATE	10.05.27		